

Work Order ID 72326

Friday, July 22, 2011 11:34:36 AM



Page 1

Item ID: D3404-1

Accept



Setup Start



Revision ID:

Stop



Item Name: GHW Lug

Start Date: 7/22/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 8/22/2011 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/07/22 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3404	Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut blank: 2.750" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1 punch.
HAAS CNC vertical machine #1

Memo

0.00

1-Machine as per Folio FA555 and Dwg D3404 □ Dwg Rev: _____ Folio Rev: _____
□ 2-Deburr

P/O: 14572

CL 11/07/22 60

120

0.00



QC2-Inspect parts off machine FAI/FAIB

QC rec'd
Quality Control

Memo

0.00

issue P/O to Dan's Precision

Machine as per dwg D3404 Rev.C

CL 11/08/23 60

rec'd + inspect for transit damage
attached c/c to w/o

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72326

Friday, July 22, 2011 11:34:36 AM



Page 2

Item ID: D3404-1

Accept



Setup Start



Revision ID:

Item Name: GHW Lug

Stop



Start Date: 7/22/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 8/22/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC & Inspect parts - second check

0.00

8/10/24

count
860



QC

Memo

Quality Control

140

Identify as per dwg & Stock Location: W/A

0.00



Packaging

Memo

030625

0.00

EL 11-8-24 x60

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/8/25

Quality Control

CL11/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 22, 2011 11:34:33 AM

Page 1

Work Order ID: 72326



Parent Item: D3404-1



Parent Item Name: GHW Lug

Start Date: 7/22/2011

Required Date: 8/22/2011

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP Rev:A ☐ 05.09.01 ☐ New issue ☐ KJ/JLM ☐

IPP rev B 09.01.28 new geometry rev.C EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.750X2.500		Purchased	No			100	f	36.0060	0.2291	14.46947			
304 BAR .750 X 2.50													



FK- 11/07/26

Location

Loc Qty

Loc Code

MAT050

36.006

115869

10.8

116765

23.206

116808

2

12.47
2.00

D3404-1P

X 60

C2 11/08/23 (60)

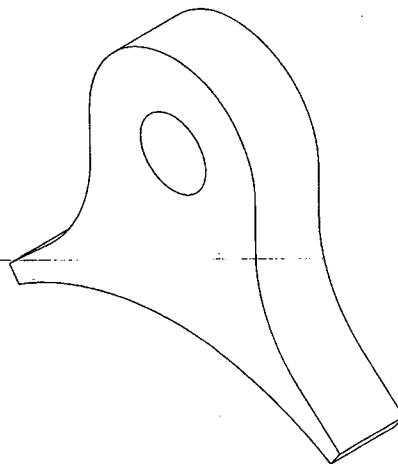
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3404-1 GHW LUG

CL1107122
W10: 72326

RELEASED
08/12/18 NW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.		AJS	08.12.02
B	UPDATE M-SPEC		PH	05.05.14
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D3404	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG	NTS	
DATE	08.12.02		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CORRECT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

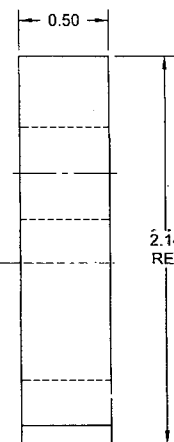
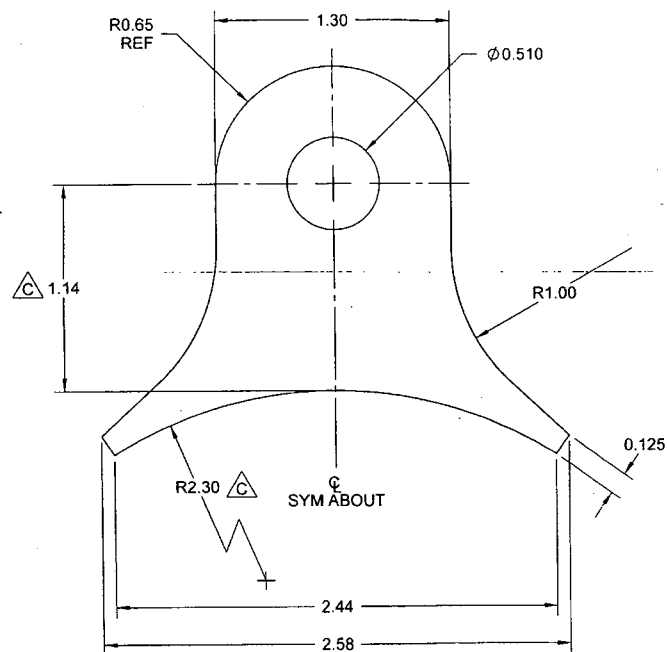
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
08/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
DATE	08.12.02	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A-3H0
Tel: (613) 835-3097 Fax: (613) 835-3760
support@dans-precision-tools.com

PACKING SLIP

Ship To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7

Number: 10677

Date: August 23, 2011

Customer's Order: PO14572

Item#	Line#	Qty	Part #	Description	Status
1	1	60	D3404-1revC	GHW Lug	Complete
2	2	40	D3414-3revC	Lug Assembly, Lug	Complete

CL11108123

Number of Packages: ☐ Boxes _____
☐ Bags _____
☐ Bundles _____

Received by: _____ Date: _____

DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel: (613) 835-3097 Fax: (613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 23-Aug-11

Purchase Order : PO14572

Packing Slip : 10677

Part Number : D3404-1 rev C

Quantity : 60

Sulodzy

Per: _____

For Dan's Precision Tools Inc.